



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-3700-C
Job Sheet 193202



Part No: RBE350A94-3700-C

Job Qty: 4 pcs *12 mcs*

Part Name: Swashplate Immobilizing Tools Adjustable Brace



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-3700-C Rev 6 IPP Rev A 17.12.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	4 pcs	5/6/19	5/6/19	0.00	0.00	Small Fab - 1		<i>MCC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	4 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	4 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S183103



Part: RBE350A94-3700-C

Job No: 193202

Serial No/Batch: S183103

Revision: 6

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MCC
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	5/6/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21 MAY 23 2019
				QC 21 - SA - 53	9-69

Part Op 110 - (Small Fab) -Bag and tag 3 RBE350A94-3700-C-1A per kit as per DWG sheet 1
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-C-1A	Adjustable Brace Assembly	12 pcs (3 ea)	110-Small Fab - 1	5183048

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	RBE350A94-3700-C-1A	12	0	0

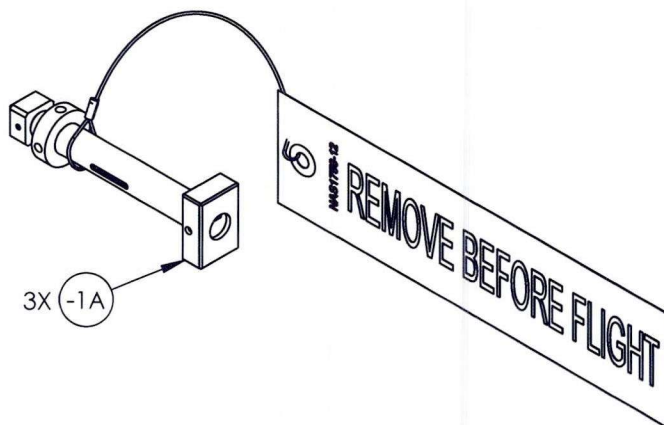
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	7/10/2015		
4A		CH'D T/N WAS RBEA94-3700-C IS RBE350A94-3700-C, DELETED ASSY. FROM TOOL NAME.	10/23/2013	CFS	RW
5	15-0213	-01 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -03 CH'D HOLE WAS Ø3.1 mm IS Ø.129 - .125, CH'D DIM WAS Ø.315 S.F. -07 IS Ø.3159 - .3150. -05 CH'D HOLE WAS Ø5.1 mm IS Ø.192 - .187. -07 CH'D HOLE WAS Ø3 mm IS .129 - .125, CH'D DIM WAS Ø.315 S.F. -03 IS Ø.3170 - .3164 ∇ .36.	8/14/2015	RJC	JAG
6	16-0286	-1A ADDED DRAWING. -01, -03, -09 -01 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -C DELETED. -01 CH'D DIM WAS Ø.620 S.F. -03 IS Ø.634 (S.F. -03), WAS .250 IS .250 +.000/- .005, WAS .130 THRU IS .132 +.010/- .000 (S.F. -11), WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), DELETED DIM Ø.750 ∇ .47 MIN S.F. -05, ADDED DIM Ø.747/.742 (S.F. -05), .49 2X FULL R. -03 CH'D DIM WAS Ø.3159/.3150 IS Ø.3159/.3155 (S.F. -07), WAS .217 IS .217 +.005/.000, WAS 2X Ø.129/.125 THRU IS 2X Ø.129/.125 THRU ALL (P.F. -11). -05 CH'D DIM WAS Ø.625 THRU ALL ∇ Ø.750 ∇ .473 S.F. -01 IS Ø.63 THRU ALL ∇ Ø.755/.750 ∇ .473 (S.F. -01), WAS Ø.192/.187 THRU ALL IS Ø.192/.187 THRU ALL (P.F. -13), WAS .217 IS .217 +.000/- .010. -07 CH'D DIM WAS Ø.3170/.3164 ∇ .36 IS Ø.3170/.3164 ∇ .37 (S.F. -03), WAS Ø.129/.125 THRU IS Ø.129/.125 THRU ALL (P.F. -11), WAS .217 IS .217 +.000/- .005, WAS .551 IS .55. -09 CH'D DIM WAS .20 IS 2X .20. ADDED -15, -17, -19.	2/28/2017	RJC	SM



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193202 MJS
19-04-09

NOTE:

CROSS REFERENCE NUMBERS:

RED BARN No.'s = HELIPRODUCTS NO.'s

RBE350A94-3700-C-01 = E-350A94-3700-25

RBE350A94-3700-C-03 = E-350A94-3700-26

RBE350A94-3700-C-05 = E-350A94-3700-27

RBE350A94-3700-C-07 = E-350A94-3700-28

FOR REFERENCE ONLY.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1A	3				2
	1		-01		TUBE	STEEL		3
	1		-03		ALL THREAD	B7 STEEL		4
	1		-05		BOTTOM	6061		5
	1		-07		TOP	6061		6
	1		-09		KNURLED NUT	STRESS PROOF		7
	2	B/O	-11		SLOTTED SPRING PIN	S.S.	Ø1/8 X 3/4 (MCMaster-CARR #92373A181)	2
	1	B/O	-13		SLOTTED SPRING PIN	S.S.	Ø3/16 X 1 (MCMaster-CARR #92373A251)	2
	1	B/O	-15		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	2	B/O	-17		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	1	B/O	-19		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	2
	ASSY -1A							

DART
AEROSPACE

TITLE SWASHPLATE IMMOBILIZING TOOL
ADJUSTABLE BRACE

DWG NO. RBE350A94-3700-C REV 6

MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/16
	.XX ± .01 ANGLES ± 5°
	X ± .1 SURFACES ± 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EUROCOPTER AS350/355
APPROVED: MACKOVJAK	
SCALE 1:8	DATE 8/21/2016 SHEET 1 OF 7

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					